

Date: Monday, 3/19/2007 4:37:31 PM
 From: Kim Johnston

Process Sheet

Split
Sp 02/05/20

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CONSOLE ASSEMBLY
Job Number	: 31295		
Estimate Number	: 11224		
P.O. Number	: <i>N/A</i>	Part Number	: D206547043
This Issue	: 3/19/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D206-547 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: F
Previous Run	: 25446	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 4/10/2007 Qty: 10 Um: Each
Checked & Approved By	: <i>[Signature]</i> 07.03.20		
Comment	: Est Rev: 06-01-05 Removed Packing Kit JLM		

Additional Product

Job Number



Seq. #:	Machine Or Operation:	Description :
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10	D2024	Extrusion, Console
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Comment: Qty.: 3.5910 Each(s)/Unit Total: 35.9100 Each(s)

D2024 Extrusion

Batch *M1*

FF 07-05-03

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT 8264-1, DT 8264-2, DT8264-3, DT8264-4

2-Deburr

FF 07-05-03

3.9. D26021 Console Side Hi Slope



Comment: Qty: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1 D2602-1

Side LH 34332

Batch

FF 07-05-04

A D: D26022 Console Side Hi Slope



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1 D2602-2

Side RH 31337

ff 07-05-04 10

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY

Job Number: 31295

Part Number: D206547043

Job Number



Seq. #:

Machine Or Operation:

Description:

5.0

D2606

Hi Console Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2606

Bracket

B 25142 x 1mx, B 31334 x 9mx -

6.0

D2607

Console Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2607

Bracket

B 22764 x 5mx, B 25143 x 5mx -

7.0

MS20470AD33

Rivet, Universal Head



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 MS20470AD3-3

Rivet

m1065 -

8.0

MS20470AD34

Rivet, Universal Head



Comment: Qty.: 20.0000 Each(s)/Unit Total: 200.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

20 MS20470AD3-4

Rivet

m15541 x 65
17690 x 135

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Grind weld relief chamfer as per Dwg D206-547

2-Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4

FF 07-05-30

5

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY

Job Number: 31295

Part Number: D206547043

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/31 (S)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Tack weld as per Dwg D206-547

A/R AL ROD Batch: M103794

FC 07/05/31 (S)

12.0

QC59

WELD INSPECTION



Comment: WELD INSPECTION

07/05/31 (S)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3

MF 07-06-01 (S)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/06/01 (S)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

- Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-L 07/06/02

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/6/04 (S)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPD B32390 D206-547-013

7/6/04 (S)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY

Job Number: 31295

Part Number: D206547043

Job Number:



Seq. #:

Machine Or Operation:

Description:

130

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

207106/04

Job Completion



U 07-06-04
M

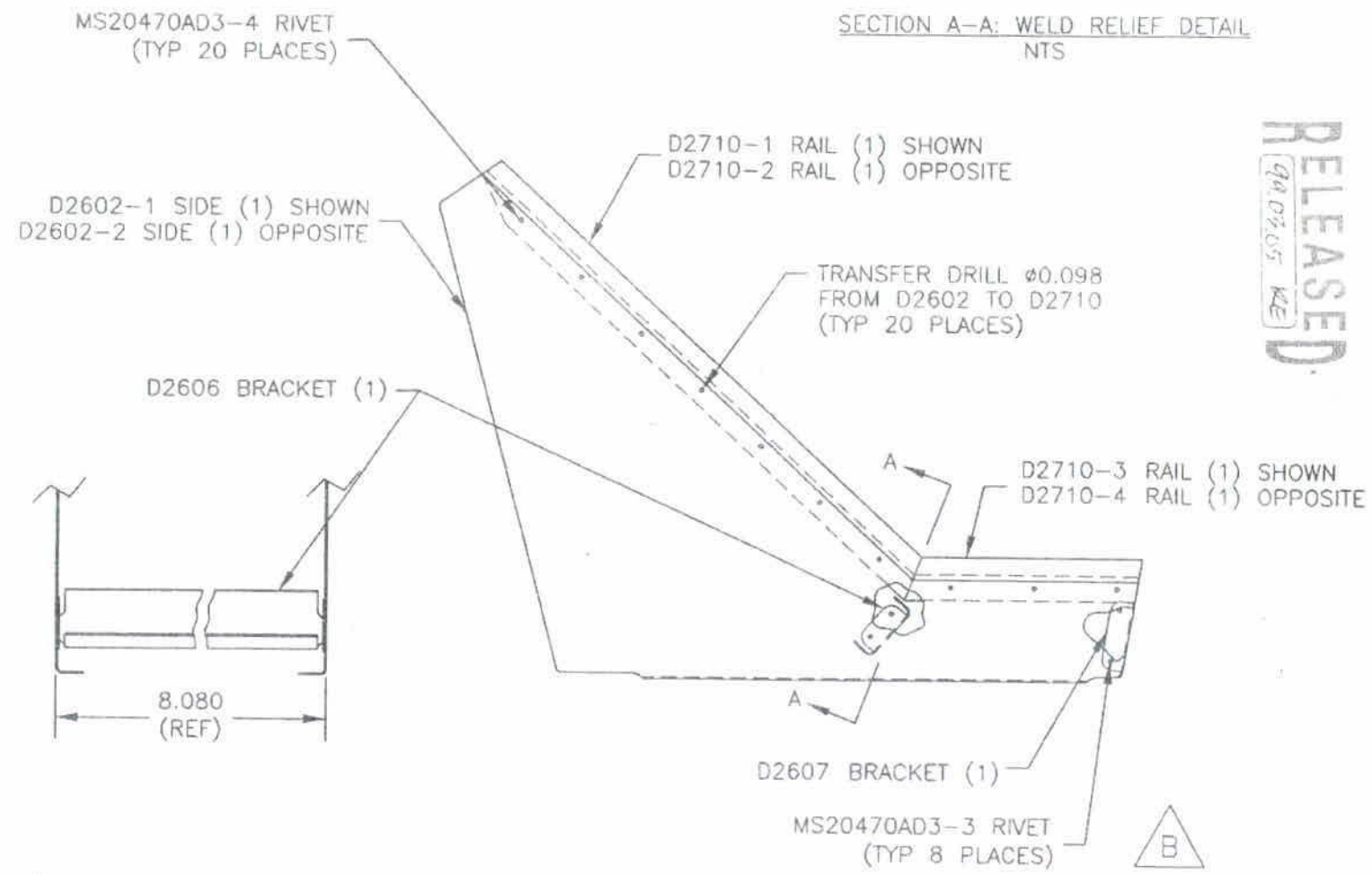
DART

RELEASED
99.02.05 KE



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D206-547-043 (206 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	RF	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	CP	APPROVED	KE	
DATE	99.02.11	DRAWING NO.	D206-547	REV: F
		TITLE	CONSOLE ASSEMBLY	SHEET 3 OF 5
				SCALE 1:4

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31295

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/05/30	9	Split w/o	S/S	07/05/30	5		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries